



Dart Aerospace Ltd.
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STK

D2666-1
Job Sheet 170516



Part No: D2666-1

Job Qty: 4 ea

Part Name: Saddle, LH, Fwd, Aft, In



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/17/18

Job Tracking No:

Due Date: 1/31/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV D IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	1/30/18	1/30/18	0.00	0.00	Start Up Machining-1		SBL 18/05/13
100	CNC Vertical Machining	4 pcs	1/30/18	1/30/18	1.54	5.71	HAAS1-2		SBL 18/05/14
110	Mill Conv	4 pcs	1/30/18	1/30/18	0.00	4.49	Mill Conv 1		SBL 18/05/14
120	QC	4 pcs	1/30/18	1/30/18	0.00	0.00	QC2 Machining-1		SBL 18/05/14
130	QC	4 pcs	1/30/18	1/30/18	0.00	0.00	QC8 Machining-1		MML 18/05/16
140	HandFinish	4 pcs	1/30/18	1/30/18	0.00	0.21	HandFinish1		BE 18-05-16
150	Powdercoat	4 pcs	1/31/18	1/31/18	0.00	0.18	Powdercoat1		BE 18-05-16
160	QC	4 pcs	1/31/18	1/31/18	0.00	0.00	QC3		1 MAY 17 2018
170	Packaging	4 pcs	1/31/18	1/31/18	0.00	0.00	Packaging3-1	ST402	1 MAY 18 2018
180	QC21-SA	4 Ea	1/31/18	1/31/18	0.00	0.00	QC21		1 MAY 18 2018

Part Op 100 - Program batch number.

Descriptions: 110 - Machine Keyway and inspect per attached dimension sheet

150 - START TIME: 10:30 CVT 1:300 FINISH 11:00

M 138839. DAS 21 9:30 MAY 22 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6101-001	4	9	0	0
S067879 → S070864					

Part Specifications

Specifications could not be found.

Plex 1/17/18 7:36 AM dart.lacelle.linda

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS																			
Part No. _____		Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐												
NCR No. _____		Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐												
		Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐												
		Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		☐												
Date :	Step #:	QTY Effective :							MRB (QS1042) Approval														
Description Work Order Deviation				Disposition																			
				Completed By																			
				Hand / Supervisor Approval Verification																			
				QA Coordinator Approval																			
 DART AEROSPACE 1270 Aberdeen Street North York, ON M6A 1K7 CANADA TEL : 1 813 832-6200 Email: sales@dartero.com www.darterospace.com				Date: 05/13/18																			
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Set up ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐				Pressure ☐ Bending ☐ Centre l ☐ Cracks ☐ Crimp/k ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐				Container No: S070865 Part: D2666 - 1 Job No: 170516 Serial No/Batch: S070865 Revision: Inspector:				Cut too short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐				Misaligned ☐ Fit/Function ☐ Misaligned/off center ☐				Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER :																							

DART AEROSPACE LTD				Work Order: 170516	
Description: 206 Saddle, Inboard, Left side				Part Number: D2666-1	
Inspection Dwg: D2666 Rev: D DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.123	.122	.123	.123	
B	0.100	0.140		.118	.119	.119	.118	
C	2.470	2.510		2.495	2.495	2.495	2.495	
D	0.100	0.180		.135	.135	.135	.135	
E	0.210	0.230	.220 →	.220	.219	.220	.220	
F	1.313	1.343		1.322	1.322	1.322	1.322	
G	0.240	0.260		.249	.249	.250	.249	
H	0.615	0.685		.665	.660	.677	.650	
I	1.125	1.145		.135	.135	.135	.135	
J	0.990	1.010		1.003	1.004	1.004	1.04	
K	0.235	0.240		.238	.238	.238	.238	
L	0.510	0.515		.510	.510	.510	.510	
M	0.100	0.120		.110	.110	.110	.110	
N	1.565	1.585		1.575	1.575	1.575	1.575	
O	5.990	6.010		5.999	6.000	6.000	6.000	
P	1.245	1.255		1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	
R	0.490	0.510		.500	.500	.500	.500	
S	0.312	0.318		.313	.313	.313	.513	
T	2.495	2.505		2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	
V	0.315	0.322		.316	.316	.316	.316	
W	0.540	0.560		.549	.549	.549	.549	
X	1.674	1.684		1.680	1.679	1.679	1.679	
Y	0.256	0.262		.257	.257	.257	.257	
Z	0.178	0.198		.188	.188	.188	.188	
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

Measured by: SBL/Am	Date: 18/05/14
Audited by: mml 10	Date: 18/05/16
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	
H	12.03.08	Dimension S and Y revised	KJ	M